Work Center ID Description Run Hours Number Rev. Code Qty Qty Number Stam Draw Nbr	Work Order ID April 12, 2010 8:50:50								•		Page 1
Start Date: 12/04/2010 Start Qty: 1.00 Cust Item ID: Required Date: 04/05/2010 Req'd Qty: 1.00 Customer: Reference: Approvals: Process Plan: Date: SPC (Y/N): Date: Stop Operation Operation Set Up/ Number Rev. Code Qty Qty Reject Reject Insp. Number Rev. Code Qty Qty Number Stam Date: Number Stam Date: Number Rev. Code Qty Qty Number Stam Date: Number Stam Document Control Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002		634-041	•	Accept					Setup Star	rt	
Start Date: 12/04/2010 Start Qty: 1.00 Cust Item ID: Required Date: 04/05/2010 Req'd Qty: 1.00 Customer: Reference: Approvals: Process Plan: Date: SPC (Y/N): Date: Stop Operation Set Up/Draw Number Rev. Code Qty Qty Reject Number Stam Operation Number Rev. Code Qty Qty Number Stam Date: Date: SPC (Y/N): Date: Stop Operation Operation Set Up/ Number Rev. Code Qty Qty Number Stam Operation Description Run Hours Number Rev. Code Qty Qty Number Stam Operation Operation Only Operation Operation Operation Run Hours Number Rev. Code Qty Qty Number Stam Operation Operation Operation Operation Operation Run Hours Number Rev. Code Qty Qty Number Stam Operation Oper	Item Name: Replace	ement Skidtube					•		Sto	р	
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Work Center D Description Run Hours Number Rev. Code Qty Qty Number Stam Draw Nb Revision Nbr D2580 Rev D	QC:		Date:	_ SPC (Y/N):	D :	ate:		•	Sto	р	
Draw Nb Revision Nbr D2580 Rev D 100 Document Control Memo Document Control Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002 110 BENDING MACHINE - SKIDTUBES CNC Bend 1' Memo 0.00 Document Control BENDING MACHINE - SKIDTUBES CNC Bend 1' Memo 0.00 Laberd as per program D2580 Cap CNC Bender and Falis ET000					·-						Insp.
Document Control Memo Document Control Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002 Document Control Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002 D000 BENDING MACHINE - SKIDTUBES CNC Bend 17 Memo D000 L-Bend as per program D2580 C on CNC Bender and Felia E1000	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1				95			À			1
DENDING MACHINE - SKIDTUBES CNC Bend 1 Memo O.00 CNC Delta 100 Bender L-Bend as per program D2580 C on CNC Bender and Felia FT000	DG \$5	Memo		0.00	, Ale		-	N	1A H2	<u></u>	
BENDING MACHINE - SKIDTUBES CNC Bend 1	Document	Pnotocopy	7 D205-634 bluefile & type	·	-041 CHG002						
CNC Delta 100 Bender 1-Bend as per program D2580.C on CNC Bender and Folio FT009	CNC Bend 1	Memo	· ·	0.00	2 1 3 4					- 10 m	
2-Cut tubes as per Dwg. D2580 4 10/4/22	CNC Delta 100 Bender			NC Bender and Folio FT	1009) H10/	4/2	2			ند مازنجا د	
			:		.,						

Dart Ae	rospace L	td						
W/O:			WC	ORK ORDER CHANGI	ES			• '
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DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approva
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspect
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Page 2

April 12, 2010 8:50:50 AM

Item ID:

D205-634-041

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

12/04/2010

Start Oty: 1.00

Required Date: 04/05/2010

Req'd Oty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: Date:

Operation

Tooling:

Date:

Run

Start

Stop

Reject

Stop



Date: _____

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date:

Draw

Rev.

Plan

Code

Accept Qty

Reject **Qty**

Insp. Number Stamp

Work Center ID

Sequence ID/

120



Skidtubes Skidtubes

Description

1- Deburr ends

Memo

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

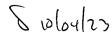
410/4/23

130

QC5- Inspect part completeness to step on W/O

Memo

0.00



Quality Control

0.00

Dart Ae	rospace l	Ltd			Ì	•	,	
W/O:			WO	RK ORDER CHANGE	ES			•
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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Part No) :	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	
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Page 3

April 12, 2010		023										Pag
Item ID: Revision ID:	D205-634-0	41	N. Control of the con	Accept					Setup S	tart		
Item Name:	Replacement	Skidtube	i						5	Stop		
Start Date: Required Date Reference:	12/04/2010 :: 04/05/2010	Start Qty: 1.00 Req'd Qty: 1.00	1888 110 1881 1888 110 110		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling:	Da	nte:]		Start		
	QC:		Date:	_ SPC (Y/N):	Da	ite:				Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours 0.00	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Skidtubes		Memo	•	0.00								•
Skidtubes		A/R 🗆 🗆 🗆	·	M113207	BE 19/0	1/26						
		004. For D2579 A/R□□□	SI 005 and weld crossbolt spacers, weld one side, pas Aluminum Rod ds as per Dwg D2580 Grin	ss 3/8" drill, weld other s	ide, pass 3/8" drill BE 10 10 4	46		•				
		4-Drill hole	s for wearplates using DT 8 er not to hit web.Deburr		V	Na	>/					
		5-Counterbo Deburr hole	ore crossbolt spacers to 7/1	6" ID x 1.0" deep as per	Dwg D2580.	17	\mathbb{Z}	\				•

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

					1			•	*	
Dart Ae	erospace Lt	t d	·							•
W/O:			W	ORK ORDER CHANGES	S					**************************************
DATE	STEP	PR	OCEDURE CH	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approv QC Inspect
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Work Order ID 57623

April 12, 2010 8:50:50 AM



Page 4

Item ID:

D205-634-041

Accept

Setup Start

Stop

Start

Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date: 12/04/2010

Start Qty: 1.00 **Required Date:** 04/05/2010

Reg'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

QC: Date:

SPC (Y/N):

Draw

Number

Date:

5 3.1

Date:

Draw

Rev.

Plan

Code

Accept

Qty

Run

Reject Qty

Reject Insp. Number Stamp

Work Center ID 150

Sequence ID/

QC

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

QC5- Inspect part completeness to step on W/O

Memo

Set Up/ **Run Hours**

1 - 1 16 3

Quality Control

Memo

170

160

HandFinish

Hand Finishing

Pressure Wash per QS1005 4.3

0.00

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

O Bh 10-4-28.

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			V	VORK ORDER CHANG	ES				.,	,
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 57623

April 12, 2010 8:50:50 AM



Page 5

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

12/04/2010

Start Qty: 1.00

Req'd Qty: 1.00 **Required Date: 04/05/2010**



Cust Item ID:

Customer:

Draw

Number

Reference:

A	nn	rov	als:	

Process Plan:

Date:

Tooling: Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Draw

Rev.

Plan

Code

10/0x/2F 1

Accept

Qty

Run

Stop

Reject

Qty

Start



Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

180



Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114267

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE

190

Quality Control

QC3- Inspect Part Finish

Memo

0.00 =7 m/ w/04/2a

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W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PROC	EDURE CH	ANGE	B	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 57623 Page 6 April 12, 2010 8:50:50 AM Item ID: D205-634-041 Accept Setup Start Revision ID: Stop Replacement Skidtube Item Name: **Start Date:** 12/04/2010 Start Otv: 1.00 **Cust Item ID:** Rea'd Otv: 1.00 **Required Date: 04/05/2010 Customer:** Reference: Run Start Tooling: Approvals: Process Plan: Date: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Reject Draw Plan Accept Reject Insp. Work Center ID Description Number Rev. **Run Hours** Code Otv Otv Number Stamp 200 0.00 HandFinish 0.00 Memo Hand Finishing 1-Install inserts & wearplates & Gaskets as per Dwg, D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R □□□ Sikaflex-291 □ ______ Sikaflex expire date: 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 mh loloy/29 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R 🗆 🗆 Sikaflex-291 🗎 Sikaflex expire date: Sikaflex expire date: 13/0 \$
5-Wing Walk as per Dwg D2580 and QSI 005 4.4

4 7 1

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W/O:			WC	RK ORDER CHAI	NGES	1				•
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Part No		PAR #:				1				
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DATE	STEP		Initial	Action Description			1			

Work Order ID 57623

April 12, 2010 8:50:50 AM



Page 7

Item ID:

D205-634-041

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

12/04/2010

Start Qty: 1.00

Required Date: 04/05/2010

Req'd Qty: 1.00



Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

SPC (Y/N):

0.00

0.00

0.00

Date: Date:

Run Start

Sequence ID/ **Work Center ID**

210



QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/

Run Hours

Draw Number Draw Plan Rev.

Accept Code Qty

Reject Qty.

Reject Number Stamp

Insp.

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per QSI 024

220

Packaging Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: PPP Rev:

PPD 57196

230

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10 105104 Ay

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W/O:			WC	ORK ORDER CHANG	ES			•
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Picklist Print		•				Page 1
April 12, 2010 8:50:55 AM						
Work Order ID: 57623 Parent Item: D205-634-041 Parent Item Name: Replacement				Start Date:	12/04/2010	Required Date: 04/05/2010
Comments: IPP Rev:NE IPP Rev P IPP Rev. O IPP Rev:P	10.02.08.28 FP was QC5 in Step 10.02.19 per PAR09-043 EC 06.02.28 Added paperwork 07-07-09 SS Wearplates &	C verified by:DD EC	D□KJ	Start Qty:		Required Qty: 1.00
D2580-1 	Manufactured No	,	110 Each	5.0000 1.0000	B-5743	67 MB 10-04-2
		Warehouse Location	Loc Oty	Loc Code		
	1 1 1	Main Warehouse LG 56975 57028	5 2 2			
D2576-3 IIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIII	Manufactured No	57188	1 140 Each •	121.0000 1.0000		
		Warehouse Location	Loc Qty	Loc Code		
		Main Warehouse LG 46661	121 73	-		BE 10/04/26
D2579	Manufactured No	52215	48 140 Each	113.0000 20.0000		70.700
		Warehouse Location Main Warehouse	Loc Oty	Loc Code		
		LG 57052	113 113		20	BE 10/04/26

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Picklist Print

April 12, 2010 8:50:55 AM

Page 2

Work Order ID: 57623

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09

SS Wearplates & Gaskets

JLM

Start Date: 12/04/2010

Required Date: 04/05/2010

Start Oty: 1.00

Required Oty: 1.00

D2855

Manufactured

200

Each

119,0000 1,0000



Cap	

Warehouse Location	Loc	<u>Oty</u>	Loc Code	
Main Warehouse				
FP6		2		
56613		2		
Main Warehouse				w/04/29
ST026		117		
50513		1		
50770		30		
51539		32		-X M-h
53791		54		
	200	Each	1,021.000 2.0000	

AN3-5A Bolt

Purchased

No

Loc Qty

Loc Code

Warehouse Location

Main Warehouse

ST350

105057

1021

1021

1xm/h 13/04/29

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W/O:			WC	RK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·		
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April 12, 2010 8:50:55 AM

Work Order ID: 57623

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

JLM

Start Date: 12/04/2010

Required Date: 04/05/2010

Start Qty: 1.00

Required Oty: 1.00

AN960JD10L

Purchased

Nο

200

200

Each

4.685.000 2.0000

Washer

Warehouse

Location

Main Warehouse ST348

110985

Loc Otv

4685

Each

Each

Loc Code

ALS7-1032-130

Purchased

Purchased

No

No

4685

409.0000 50.0000

Insert

Warehouse

Loc Qtv

Loc Code

Location

Main Warehouse

ST282

113238

200

409

1,499,000 50,0000

AN3C4A

BOLT

Warehouse

Loc Otv

Loc Code

Location

Main Warehouse ST350 113226

114103 114108 114330

98 501 400

500

April 12, 2010 8:50:55 AM

Shop Packet Print

Dart Aerospace Lt	d	
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April 12, 2010 8:50:55 AM

Work Order ID: 57623

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P

Manufactured

Manufactured

Manufactured

NAS11490332R

SS Wearplates & Gaskets 07-07-09



Start Date: 12/04/2010

Required Date: 04/05/2010

Required Qty: 1.00

AN960C10L

washer D3566-13



Purchased

No

No*

No

200

200

200

200

M114341

Each

Each

0.0000

53.0000

Loc Code

50.0000

Start Qty: 1.00

1.0000

Gasket

Warehouse Location

JLM

Main Warehouse

FP

53461

Loc Qty

53 53

Each

11.0000 1.0000

Loc Code

_m.1.104/29



Gasket

D3566-5

Warehouse

Location

Main Warehouse FP015

56829

B 57526

Loc Qty

11 11

Each

22.0000

Loc Code

2.0000

Gasket

D3566-1

Warehouse

Location Main Warehouse

57257

FP015

Loc Qty

22 22 2xm/ w/04/29

1x m. / w/04/29

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Page 5

Work Order ID: 57623

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork

SS Wearplates & Gaskets IPP Rev:P 07-07-09

JLM

Start Date: 12/04/2010

Required Date: 04/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-11

Manufactured

Manufactured

No

No

200

Each

Each

1.0000

1.0000

Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

56834

200

22.0000

1.0000

D3564-13

Wearshoe

Warehouse Location

Main Warehouse

FΡ

56285

Main Warehouse FP17

56533

Loc Qty

4

18

18

Loc Code

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Required Date: 04/05/2010

Required Qty: 1.00

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April 12, 2010 8:50:55 AM

Work Order ID: 57623

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

No

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

Manufactured

Manufactured

IPP Rev. O 06.02.28 Added paperwork

SS Wearplates & Gaskets IPP Rev:P 07-07-09

JLM

200

Each

13.0000

1.0000

Start Date: 12/04/2010

Start Qty: 1.00

Wearshoe

D3564-9

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse	-14 20	
FP	1	
55334	1	
Main Warehouse		
FP019	12	
57260'	12	

D3564-5

Wearshoe

No

200

Each

13.0000

1.0000

Warehouse Loc Oty Loc Code Location B57525 **OFFSHORE** FG 34806 2 Main Warehouse FP 11 55024 55333 10

Dart A	erospa	ce Ltd
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Page 7

Work Order ID: 57623

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

JLM

Start Date: 12/04/2010

Required Date: 04/05/2010

Start Qty: 1.00

Required Oty: 1.00

D2594-3

Manufactured

Manufactured

200

Each

220.0000 16.0000

Loc Code



O-Ring, 205 Skidtube

Warehouse Location

Main Warehouse FP

55546

Loc Oty

220

220

Each

427.0000 16.0000



D2594-1

Plug, 205 Skidtube

Warehouse

Location Main Warehouse

FP

42807 55002 Loc Oty

Loc Code

427 112 315

16x min 1/20

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DESIG	H	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED	APPROVED	DRAWING NO.	REV. D
			D2580 SHEET	1 OF 3
DATE			TITLE	SCALE
07.0	02.27		205 SKIDTUBE ASSEMBLY	NTS
A.		96.09.16	NEW ISSUE	
В		96.12.02	AS MANUFACTURED	
С		98.08.26	REDRAWN, INCLUDED DEO 9094/909	97
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	



	T		
QTY	QTY	Part Number	Description
-041	-045		
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
11	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13 ·	GASKET
50	50	ALS7-1032-130	INSERT
		or AKS7-1032-130	
		or AKS4-1032-130	
		or AELS-1032-130	
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOUNT Y PUTURN TO PUTURN TO UNCCLATROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 5.26.23

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

SEE NOTES ON PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

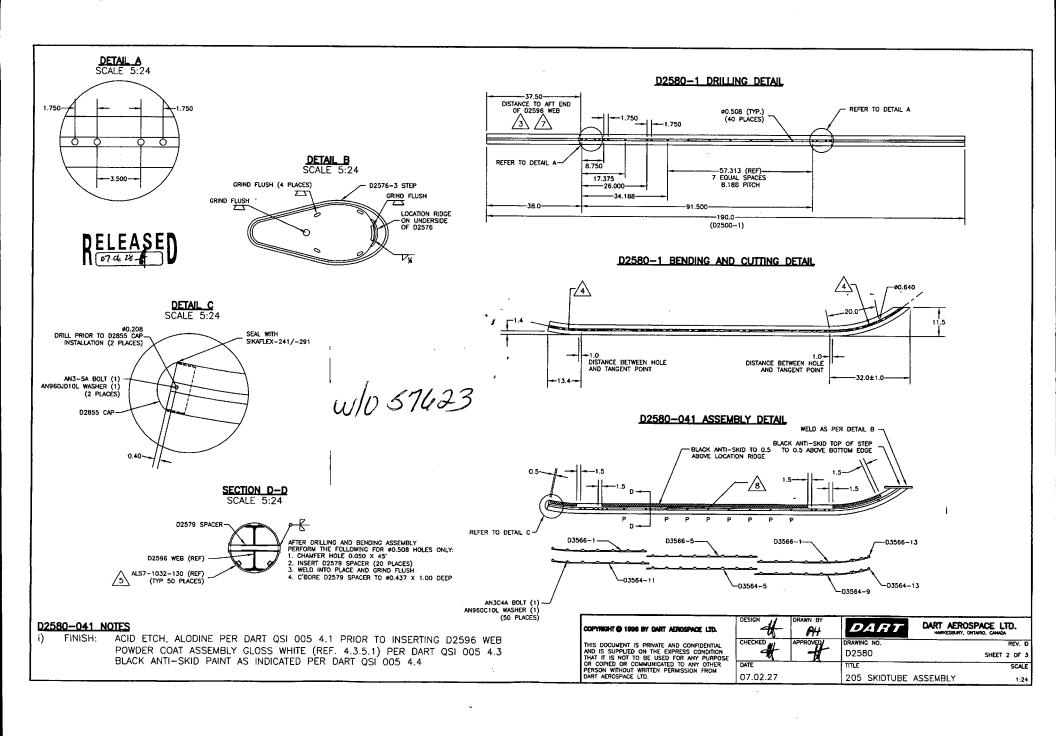
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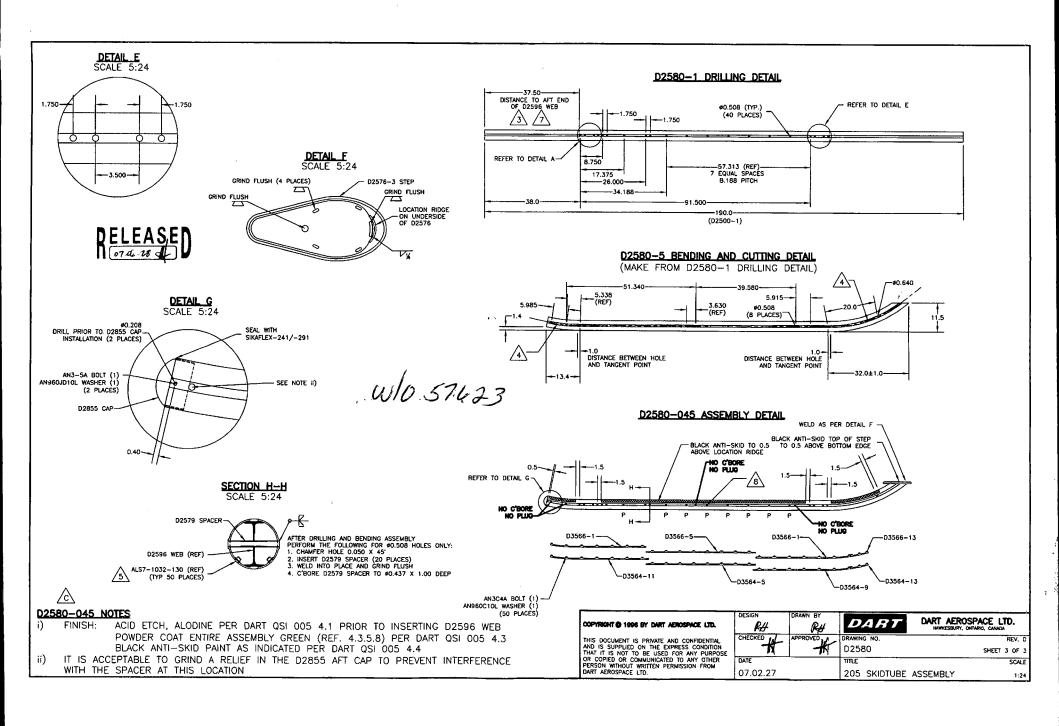
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AWS D17.1.2001 QUALIFICATION TEST RECORD

3	
Name: Bardon Elliott	
Job number: <u>ろうしょう ()</u>	
Part number: DOOS - 634.041	
Description: 205 skid Aube	
Welding Process: Tig[] Mig[]	
Base materiel: Aluminium	
Current: AC[Y DC[]	
-	

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[V] pass[V]	fail[] fail[]
UNACCEPTABLE		
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] pass[] pass[] pass[] pass[] pass[]	fail[] fail[] fail[] fail[]
Qualifier 104 Port	_	est Coupon 10.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld